

Work Order ID 50574

July 16, 2009 8:16:00 AM



Page 1

Item ID: D3838-041

Accept



Setup Start



Revision ID: A

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-07-16 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-1 and D3838-3 rib as per dwg D3838 12- c/sink hole as per
dwg 13- remove identification markings 14- deburr

SAD 09-07-16

Qty
2

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8 09/07/16

Qty
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50574

July 16, 2009 8:16:00 AM



Page 2

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Required Date: 07/22/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838 ☐ A/R ER316 S.S. Rod
Batch: M108775 ☐ 2- grind weld flush where indicated on dwg D3838 ☐
3- weld D3759-1 bushing as per dwg D3838 ☐ 4

SP 09.07.20

130

0.00



QC

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

Quality Control

PC 09.07.20

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

=>

S 07/14/09

041

(12)

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50574

July 16, 2009 8:16:00 AM



Page 3

Item ID: D3838-041

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Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Basket cell

Memo

0.00

SY 09/07/20

-041

21

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/21

MF 09-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 16, 2009 8:15:59 AM

Page 1

Work Order ID: 50574

Parent Item: D3838-041RevA

Parent Item Name: Rib Assembly (Basket Lid, LH)


Start Date: 07/17/2009

Required Date: 07/22/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA		Manufactured	No			100	Each	60.0000	2.0000			
												
Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 24

48331 24

Main Warehouse

WA 36

50000 36

M304TS0.750W.065

Purchased

No

120 f

174.1729 2.1720



304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 174.172879

110969 3.29

111148 15.96

111331 1.96

111432 0.44

111885 5.9122

112051 146.610679

2.1720

SAD 09-07-15

(Qty 2)

sp 09.07.20 -

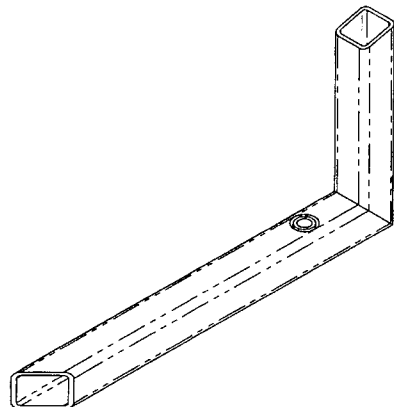
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

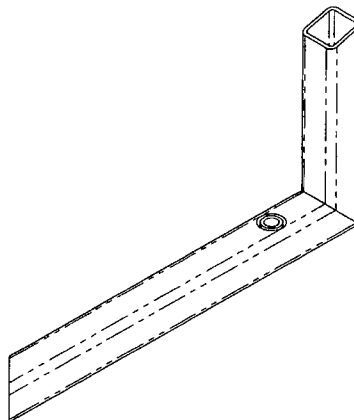
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

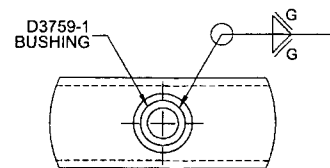
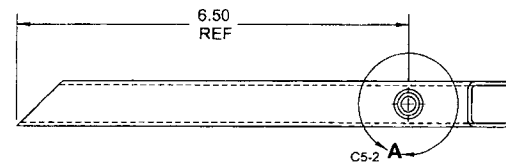
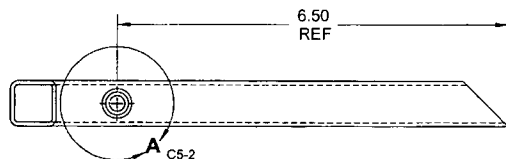
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WORK ORDER
NO. 50574
MF 09-07-16

RELEASED
08/10/08

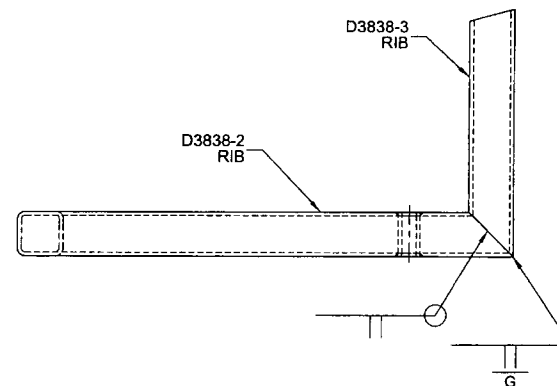
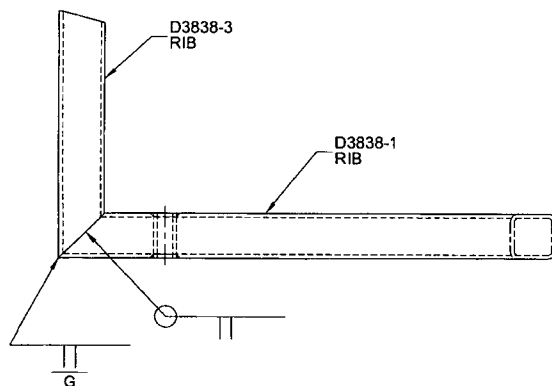
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1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3838	SHEET 1 OF 3
TITLE	RIB ASSY (BASKET LID)	SCALE NTS
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DETAIL A
D2-2
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)

D3838-042 RIB ASSY (BASKET LID, LH)

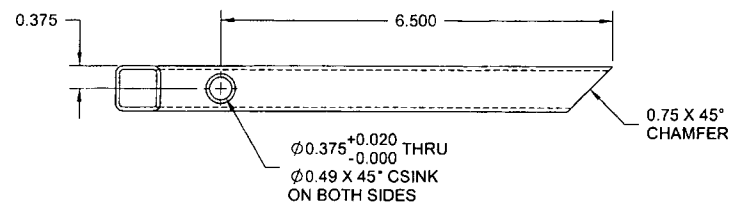
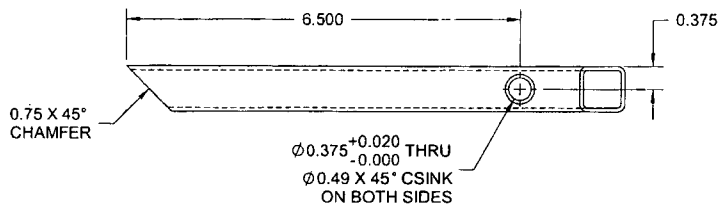
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NO. 50574
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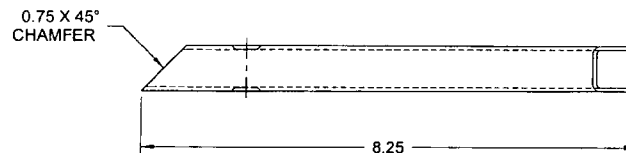
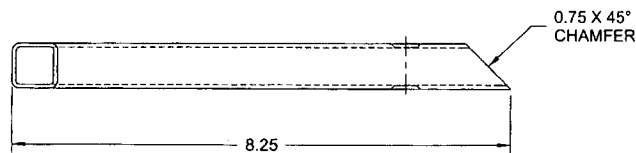
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3838	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

D



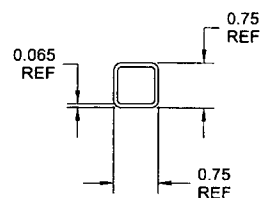
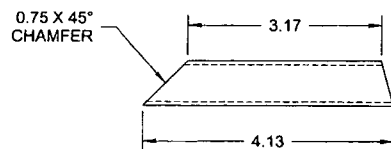
C



D3838-1 RIB

D3838-2 RIB

B



D3838-3 RIB

TYPICAL SECTION VIEW

RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

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WORK ORDER

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3838	REV. A
CHECKED			SHEET 3 OF 3
MFG. APPR.		TITLE RIB ASSY (BASKET LID)	SCALE NTS
APPROVED		DATE 08.10.08	
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NO. 50574

MF 09-07-16

8 7 6 5 4 3 2 1